

Work Order ID 64424



Page 1

Monday, December 06, 2010 8:54:10 AM

Item ID: D3537-1

Accept



Setup Start



Revision ID:

Item Name: Wearpad

Stop



Start Date: 12/6/2010 Start Qty: 60.00



Cust Item ID:

Required Date: 12/13/2010 Req'd Qty: 60.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 10/12/07

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3537

Rev C

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3537 □ Dwg Rev: C □ Prog Rev: C □ 2-Deburr if necessary

364. 063

10-12-7

(Handwritten mark)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

10-12-7

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

10/12/07

10/12/07
(72)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Start Date: 12/6/2010 Start Qty: 60.00

Required Date: 12/13/2010 Req'd Qty: 60.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130



Brake NC

Brake NC

NC BRAKE

Memo

1-Form as per Dwg D3537 on CNC brake using Jigs DT 8261 and DT 8326. 2-Identify as D3537-1

0.00

0.00

72

SD 10/12/08

140



Large Fab

Large Fab

Large Fab

Memo

Qty Description Batch A/R 2059B Hardcoat
11/6047 1-Weld as per Dwg D3537 using Jig DT 8210 2-Remove any weld that penetrated through Wearpad if necessary

0.00

0.00

EL 11/01/00 72x

150



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

Memo

0.00

0.00

Subtotal

counts 72

W/O:		WORK ORDER CHANGES					
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Item ID:	D3537-1	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Wearpad					
Start Date:	12/6/2010	Start Qty: 60.00		Cust Item ID:		
Required Date:	12/13/2010	Req'd Qty: 60.00		Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				cauto (x72)			
170  Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 M 112 588 Memo START TIME: 10:15 FINISH TIME: 10:45	0.00 0.00						72 BR 11-01-11	
180  QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00						72	

W/O:		WORK ORDER CHANGES					
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Revision ID:

Stop



Item Name: Wearpad

Start Date: 12/6/2010 Start Qty: 60.00



Cust Item ID:

Required Date: 12/13/2010 Req'd Qty: 60.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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190

Identify as per dwg & Stock Location: FP-17

0.00



Packaging

Memo

0.00

Packaging

72 0 24 11/01/11

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/01/12
MKF

11-01-11

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Picklist Print

Monday, December 06, 2010 8:54:14 AM

Page 1

Work Order ID: 64424



Parent Item: D3537-1



Parent Item Name: Wearpad

Start Date: 12/6/2010

Required Date: 12/13/2010

Start Qty: 60.00

Required Qty: 60.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S16GA

Purchased

No

100

sf

125.7000

0.106

6.694737



12-10-12-7

304/316 Sheet .063

Location

Loc Qty

Loc Code

MAT

125.7

111323

0

115688

1.7

115953

124

115953

72

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SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

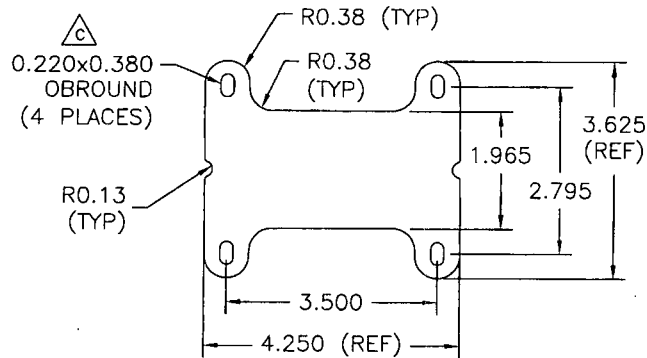
SUBJECT TO AMENDMENT

WITHOUT NOTICE

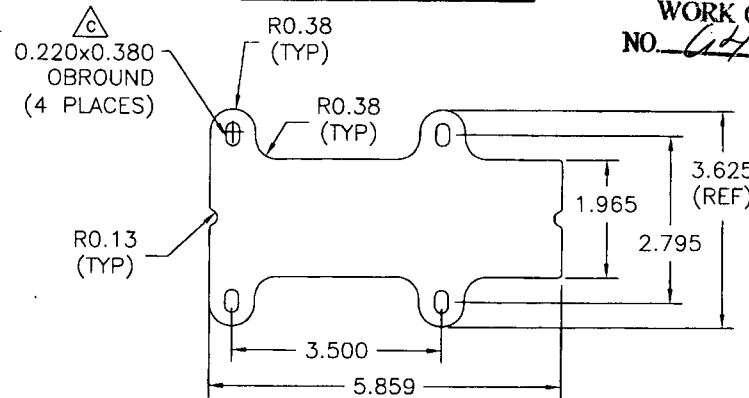
WORK ORDER

NO. 64429

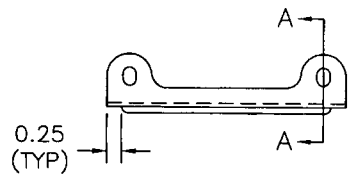
D3537-1F FLAT PATTERN



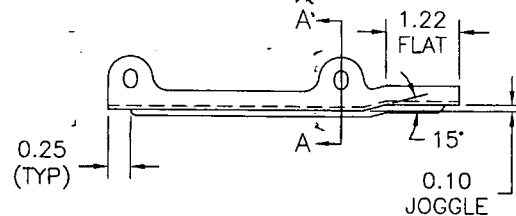
D3537-3F FLAT PATTERN



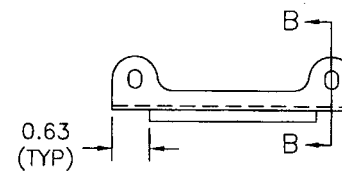
D3537-1 LONGITUDINAL BEND (MADE FROM D3537-1F)



D3537-3 LONGITUDINAL BEND (MADE FROM D3537-3F)



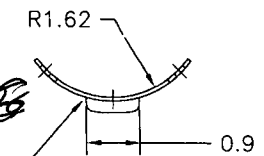
D3537-5 LONGITUDINAL BEND (MADE FROM D3537-1F)



D3537-1/-3/-5/-7 WEARPAD NOTES

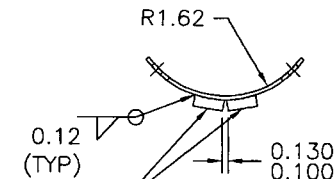
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

SECTION A-A



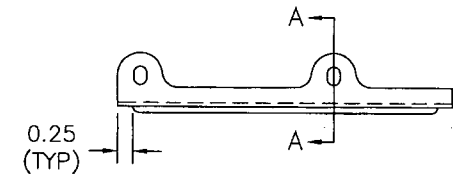
APPLY 2 LAYERS OF 2059B HARDCOAT WELDS TO WITHIN 0.25 OF WEARPAD ENDS 0.188 TO 0.250 THICK

SECTION B-B



D2941-300 REMOVE POWDER COAT FROM THESE SURFACES

D3537-7 LONGITUDINAL BEND (MADE FROM D3537-3F)



RELEASED
07.05.03 AH
per ELN
962

C	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.11.06	NEW ISSUE
DESIGN	C.B.	DRAWN BY P.H.
CHECKED	A.	APPROVED A.
DATE	07.04.13	
DRAWING NO.	D3537	REV. C
TITLE	WEARPAD	SHEET 1 OF 1
		SCALE 1:2

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DART DART AEROSPACE USA, INC.
PORT HADLOCK, MA

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